

ENG

PD038

Work Order ID 51202



August 7, 2009 2:20:15 PM

Item ID:	D2989-043	Accept		Setup	Start	
Revision ID:	D				Stop	
Item Name:	Basket Lid Assembly					
Start Date:	8/10/09	Start Qty:	1.00		Cust Item ID:	
Required Date:	8/21/09	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2989	Rev D								

100		0.00							
	Large Fab								
Large Fab									
Large Fab									
	Memo	0.00							
	1- assemble all ribs in DT9446 jig, weld as per dwg D2989								
	2- tack weld mesh on basket as per dwg D2989 using DT9446 jig								
	3- to locate hinges and shims use D2989-041, weld as per dwg D2989								
	A/R ER316 S.S. Rod Batch: M109213								

PL 09-08-19

110		0.00							
	QC9- Inspect visual per QSI004- Fusion Welds								
QC									
Quality Control									
	Memo	0.00							

PD 09-08-20

Work Order ID 51202

August 7, 2009 2:20:15 PM



Page 2

Item ID: D2989-043

Accept



Setup Start



Revision ID: D

Stop



Item Name: Basket Lid Assembly

Start Date: 8/10/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/21/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

1-Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

***** 2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

Do NOT PAINT

ENG - SEE ATTACHED EMAIL

Work Order ID 51202

August 7, 2009 2:20:15 PM



Page 3

Item ID: D2989-043

Accept



Setup Start



Revision ID: D

Stop



Item Name: Basket Lid Assembly

Start Date: 8/10/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/21/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
150 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
160 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

ENG - see attached email

RW0308
u w0311

L Lacelle

From: Mike Petsche [mpetsche@dartaero.com]

Sent: August 7, 2009 11:42 AM

To: 'L Lacelle'; 'Melanie Fauteux'

Cc: 'Alan Stocker'; 'Dan Stow'

Subject: Two basket lids

Mel/Linda

Por favor...

We need two AS350 basket lids. We need a SHORT basket – full lid, and a Long Basket Split Lid....We'll try to be careful with them so that they can be returned to inventory when we're done....(not powder-coated)

No hurry.....sometime in the next couple of weeks.

Thanks

Mike Petsche
Design Manager
DART Aerospace
phone: 613-632-5200
mobile: 514-833-1657
skype: mike.petsche

8/07/09

Picklist Print

Page 1

August 7, 2009 2:20:14 PM

Work Order ID: 51202



Parent Item: D2989-043RevD



Parent Item Name: Basket Lid Assembly

Start Date: 8/10/09

Required Date: 8/21/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2221-1RevH

Manufactured

No

100

Each

5.0000

1.0000



Rib

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

48101

1

48427

4

D2989-3RevD

Manufactured

No

100

Each

4.0000

1.0000



Rib

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4

48506

2

50572

2

D2989-4RevD

Manufactured

No

100

Each

4.0000

1.0000



Rib

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4

48503

2

50572

2

CP 09-08-11 ✓

CP 09-08-11 ✓

CP 09-08-11 ✓

Picklist Print

August 7, 2009 2:20:14 PM

Work Order ID: 51202



Parent Item: D2989-043RevD



Parent Item Name: Basket Lid Assembly

Start Date: 8/10/09

Required Date: 8/21/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2989-5RevD

Manufactured

No

100

Each

10.0000

2.0000



Rib

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

10

48330

2

48505

4

50576

4

D3182-1RevA

Manufactured

No

100

Each

10.0000

2.0000



Hinge

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

10

45504

1

48453

9

D3442-3RevA

Manufactured

No

100

Each

8.0000

2.0000



Shim

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8

42718

1

48504

7

CP09-08-11 ✓

CP09-08-11 ✓
CP09-08-11 ✓

CP09-08-11 ✓

August 7, 2009 2:20:14 PM

Shop Packet Print

Picklist Print

Page 3

August 7, 2009 2:20:14 PM

Work Order ID: 51202

Parent Item: D2989-043RevD

Parent Item Name: Basket Lid Assembly


Comments:

Start Date: 8/10/09

Required Date: 8/21/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3827-041RevA		Manufactured	No			100	Each	7.0000	1.0000			
												
Rib Assembly (Inboard)												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1

48454

1

Main Warehouse

WA

6

51091

6

D3832-5RevA

Manufactured

No

100

Each

6.0000

1.0000



Mesh (Lid)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

6

48216

3

50020

3

Pl 09-08-11 ✓

Pl 09-08-17 ✓

August 7, 2009 2:20:15 PM

Shop Packet Print

Page 3

Picklist Print

August 7, 2009 2:20:15 PM

Work Order ID: 51202

Parent Item: D2989-043RevD

Parent Item Name: Basket Lid Assembly


Comments:

Start Date: 8/10/09

Required Date: 8/21/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3833-5RevA		Manufactured	No			100	Each	4.0000	2.0000			
												
Mesh (Lid End)												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

4

44767

4

D3838-041RevA

Manufactured

No

100

Each

4.0000

1.0000



Rib Assembly (Basket Lid, LH)

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

4

48502

2

50574

2

D3838-042RevA

Manufactured

No

100

Each

4.0000

1.0000



Rib Assembly (Basket Lid, RH)

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

4

48501

2

50575

2

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

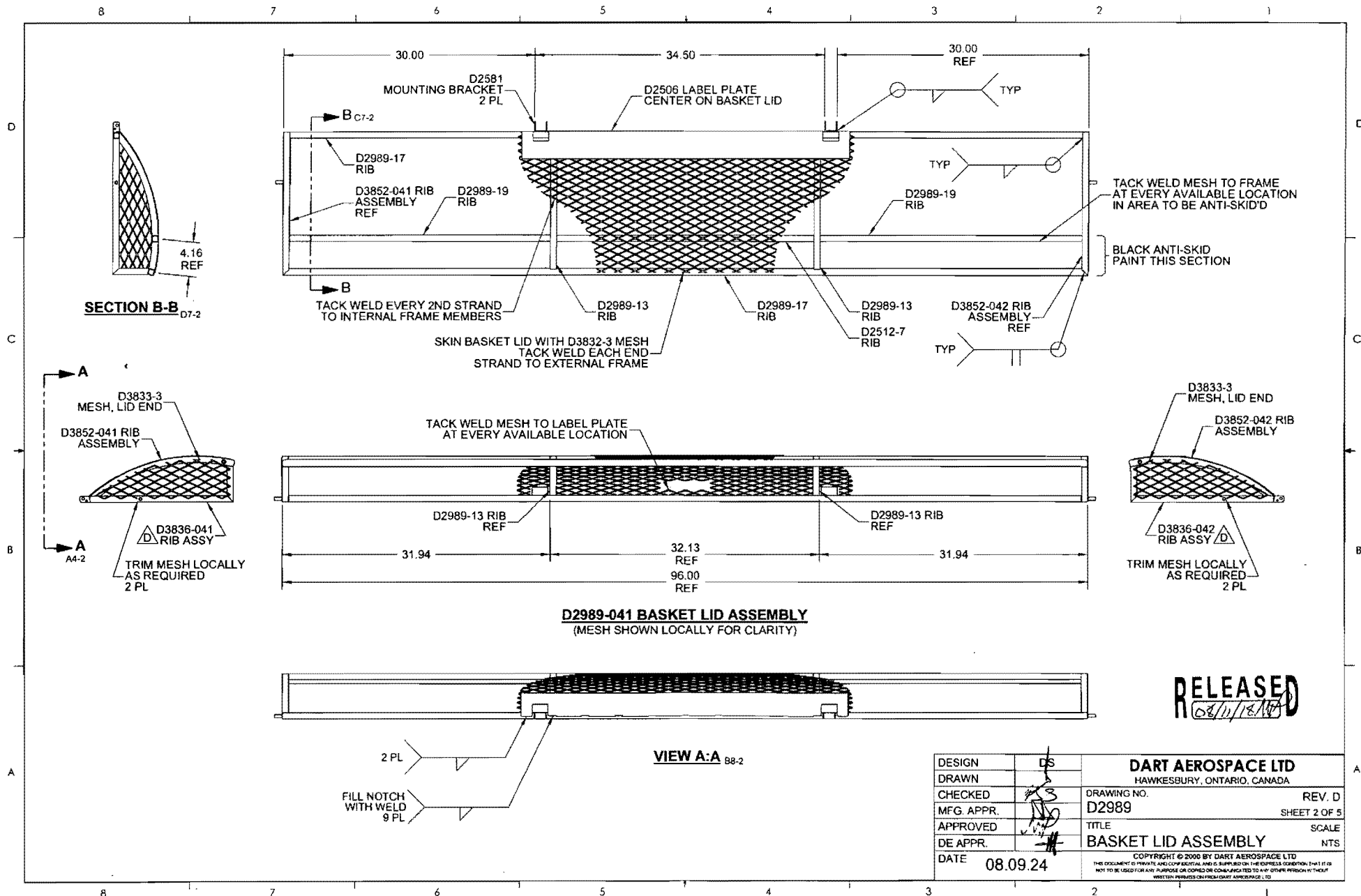
NOTES:



- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

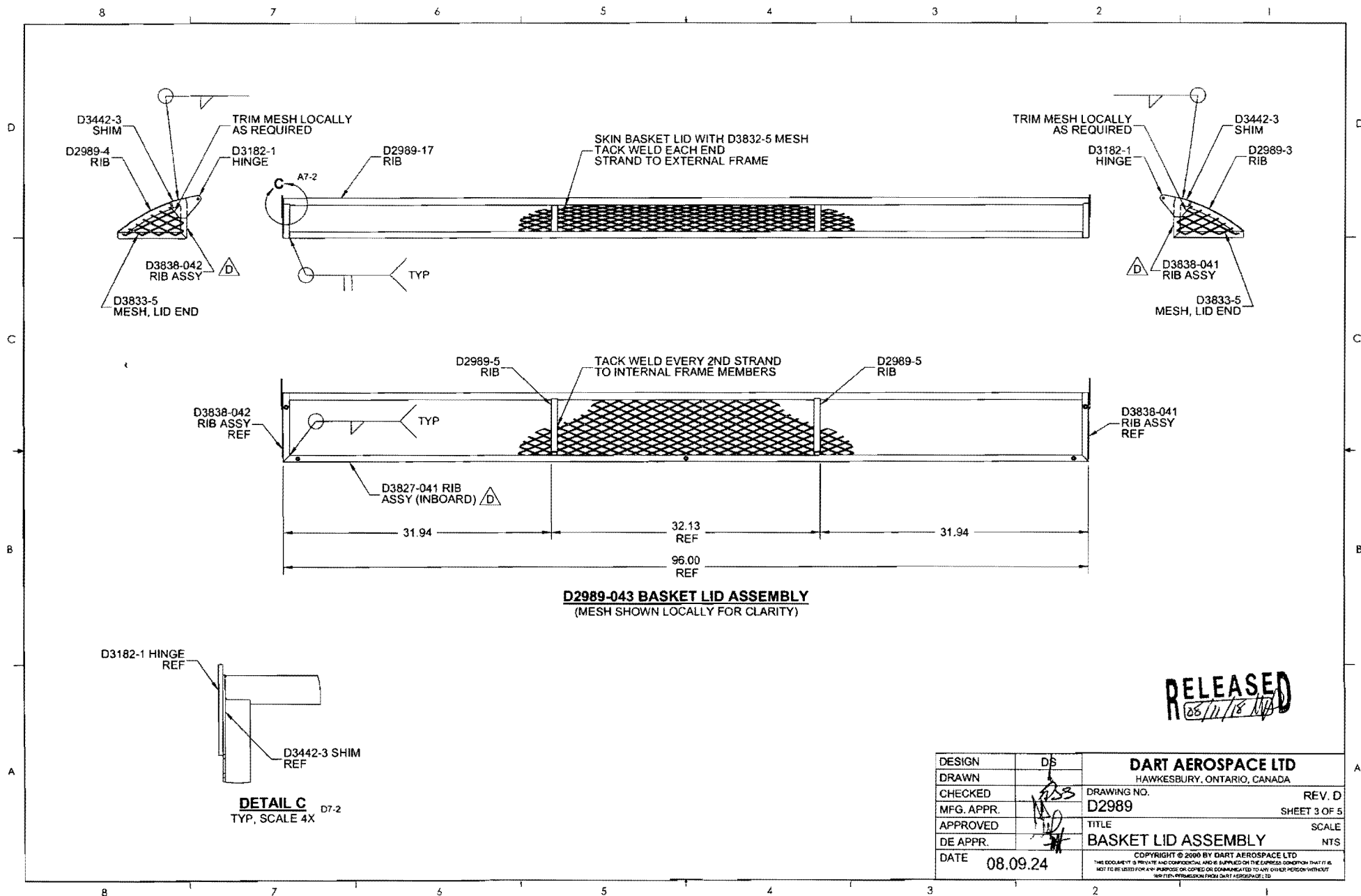
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

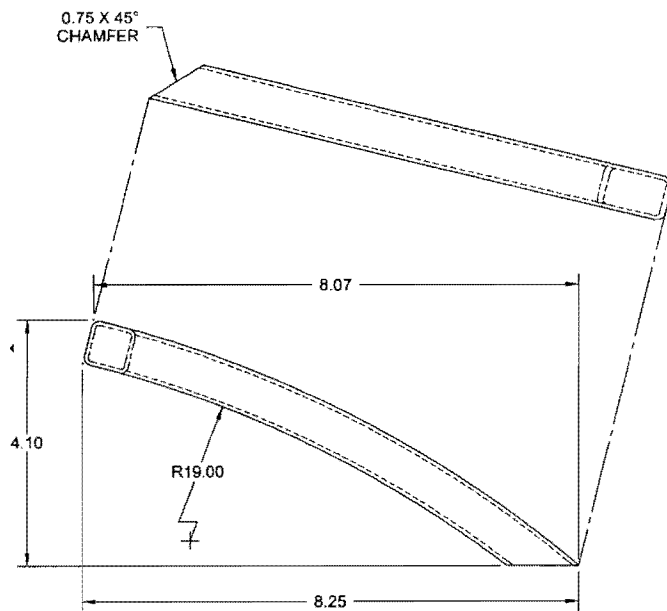
RELEASED
08/11/2024

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG), D2989-9/-10 (NOW ON D3836 DWG), D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

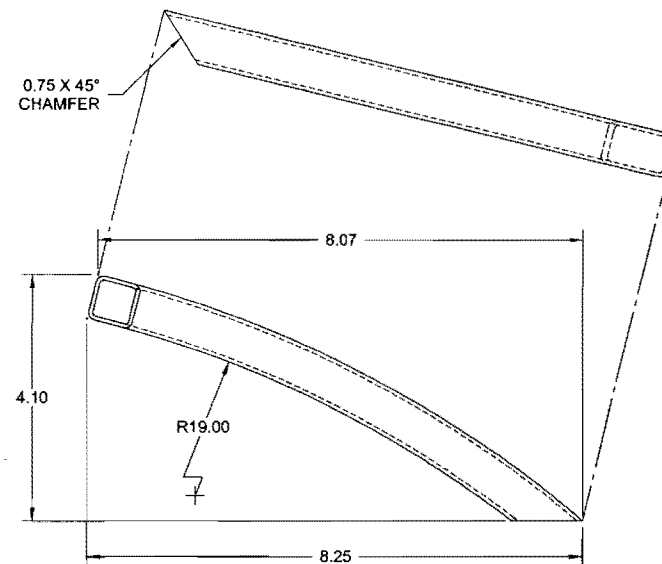


DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

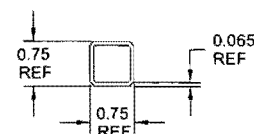




D2989-3 RIB






D2989-4 RIB



**TYPICAL SECTION
VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

RELEASED
08/11/18 N/A

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMBINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

